DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023277
Date Inspected: 07-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly
This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E PP123
PCMK: VP3007-001
Weld No: 053,057
Welder: 058102
Weld Repair No. B-WR20769
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 14E PP123
PCMK: VP3009-001
Weld No: 006,009
Welder: 058102

Weld Repair No. B-WR20767
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 14 E PP128.3
PCMK: SEG3019D-2
Weld No: 189,193,188,196,212
Welder: 215553
Weld Repair No. B-WR20931
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E
PCMK: SEG3019E-2
Weld No: 217,209,189,184,192
Welder: 044779
Weld Repair No. B-WR20932
WPS-345-SMAW-3G(3F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

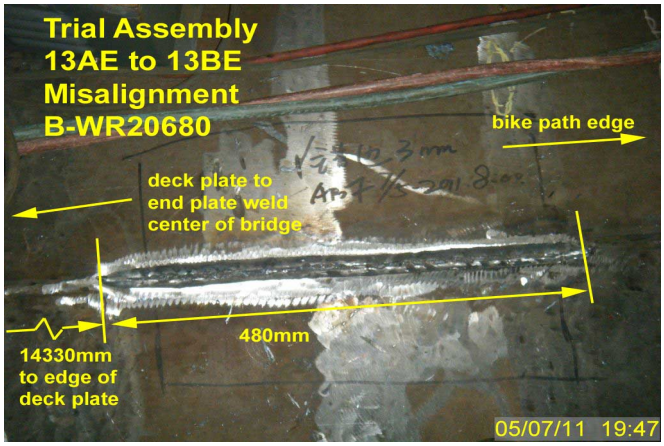
Components; OBG 13CE
PCMK: SA3060-003
Weld No: 003,005
Welder: 050977
WPS-B-T-2232-ESAB

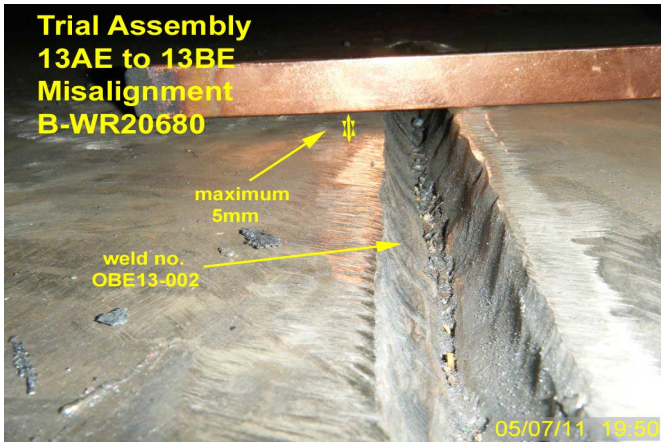
Components; OBG 13CE
PCMK: SA3060-004
Weld No: 003,005
Welder: 050977
WPS-B-T-2232-ESAB

ZPMC was observed re-aligning the vertical plane of deck plate 13AE to 13BE, weld number OBE13-002, that was previously welded. The welding repair report number B-WR20680 stated “after inspection 13AE and 13BE deck plate misalignment, it was a maximum of 5mm and need to cut”. The filler metal was removed from the weld in two places, one starting at 7650mm from deck plate to end plate weld center of bridge 1500mm long, the other starting at 14330mm from deck plate to end plate weld center of bridge 480mm long. Realignment was achieved, weld joint prepped, preheat used and the weld material was replaced using the flux core arc welding method with ESAB wire. ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang. (see photos)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

documents.





Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer